

Work Order ID 92197

October-24-12 11:43:31 AM

92197

Page 1

Item ID: D6104-003 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Round Billet, 17-4
Start Date: 10/23/12 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 11/16/12 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MLJ Date: 12-10-24 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D6104	Rev B								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>18248</u> a)Description: S.S round billet b) Ø3.25" x 3.80" longc) Tolerance on all dimensions are +0.030"/-0.000"d) Material: 17-4PH Stainless steel (Ams 5643 or Aisi 630)e)One blank makes 2 partsf) Material certification required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg D6104								

CL 12/10/25 (10)

R 12/14/6 (10)

and 12/11/06

10 P DAS 14

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Work Order ID 92197

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Page 2

October-24-12 11:43:31 AM

Item ID: D6104-003 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Round Billet, 17-4
 Start Date: 10/23/12 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 11/16/12 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>MAT 43</u>	0.00							
130									
Packaging	Memo	0.00				10	0		DAS 12/11/12
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							12/11/12
Quality Control									

12-11-06

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
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Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
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Picklist Print

October-24-12 11:43:31 AM

Page 1

Work Order ID: 92197

Parent Item: D6104-003

Parent Item Name: Round Billet, 17-4

Start Date: 10/23/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP B: 01.09.04 Revised Step 2 SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-003P 17-4 SS Roundbar 3.25"OD		Purchased	No			110	Each	0.0000	1	10		10/24/12	(10)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE





DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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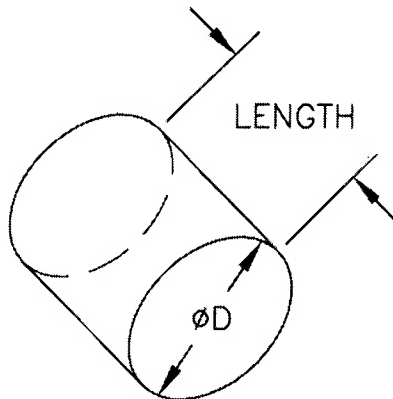


DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D6104 Rev. B SHEET 1 OF 1	
DATE 02.11.25			TITLE ROUND BILLET, 17-4 SCALE NTS		
A	01.04.10		NEW ISSUE		
B	02.11.25		CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS		

RELEASED

02.11.29

SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRC)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER X LENGTH (+0.030/-0.000) AS SHOWN.

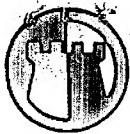
TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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**Castle Metals®**

A. M. Castle & Co.

**PACKING SLIP/
CERTIFICATE OF CONFORMANCE**

Page 1 of 1

Shipment No: 1527785

Ship From: A. M. Castle & Co. (Canada) Inc. MONTREAL 835-SELKIRK AVENUE POINTE CLAIRE, QUEBEC H9R 3S2		Sold To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA		Ship To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CAN		Deliver To: DART AEROSPACE LTD 1270 ABERDEEN HAWKESBURY, ON K6A 1K7 CA	
Date Shipped 02-NOV-2012	F.O.B. ORIGIN	Freight Terms Prepaid		Carrier UPS		BOL No 1527785-2	

Shipment Details			Final Destination Branch - MON				
Order No	Line No	Item No	Description				
2507235	1	42470.MO	3.2500.RD.17CR-4NI.STAINLESS.RT.SOL TR.COND A.132.0000-156.0000 CUT TO 3.8 IN (+ .0620/- .0000 IN) -BAND SAW CUTTING SPECIFICATIONS: AMS 5643				
Purchase Order No		Part Number	Ordered Qty			Invoice Qty	
18248		YOUR ITEM NUMBER: D6104-003P	10.00 PCS			10.00 PCS	
Details							
Delivery No.	Mill	Heat Number	Mech Id	PCS	Width (IN)	Length (IN)	Shipped Qty(LBS)
118104737	NORTH AMERICAN STAINLESS	9EY4		10			89.3327

These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.

We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit.

Reviewed by Authorized Castle Metals Representative:

Date:

Name:

DAS
14
9-89

These commodities, technology or software were exported from the United States in accordance with the Export Administration Regulations. Diversion contrary to US law prohibited.
Date Printed: 02-NOV-2012 01:39:51 PM



NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 644968 18
Customer: 0032 001
Purchase Order: LN 72107 1
Purchase Order: 104195

Mail To:
A.M. CASTLE AND COMPANY
3400 NORTH WOLF ROAD
FRANKLIN PARK IL 60131

Ship To:
A.M. CASTLE AND COMPANY
3400 NORTH WOLF ROAD
FRANKLIN PARK IL 60131

Date: 5/22/2011 Page: 1 of 1
Steel: 630(17-4)
Finish: Hot Finish
Dia/Thk: 3.2500 in
Leg Length:
Length: 144.00 in
Corrosion:

Item Code: 42470

PRODUCT DESCRIPTION:

MS 2303E, AMS 5643R
Round Bar, Hot Rolled, Annealed, Rough Turned
MS S17400; EN 10204 3.1B, ASTM A484/08
BTM A564/10 ASME SA564-07

REMARKS:

COMPLIES W/REQUIREMENTS OF DFARS EU DIRECTIVE 2002.95.
EC. RoHS. EAF+AOD+CC. NO WELD REPAIR. MELTED AND MFG IN USA
FREE FROM MERCURY AND LOW MELTING ALLOY CONTAMINATION

DAS
14
2-83

Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight	Bundle Weight
BD83189	2410								

CHEMICAL ANALYSIS

CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan)

Heat	Supplier #	CM	C	CB	CO	CR	CU	MN	MO	N	NI	P
9EY4		US	.034	.233	.06	15.33	3.20	.54	.16	.040	4.27	.030
			S	SI	TA	TI						
			.0095	.66	.0055	.0020						

MECHANICAL PROPERTIES

	Id o i c x	HB No.	Ferr %	TS-C KSI	YS-C KSI	El-C %	RA-C %	RC-C No.
BD83189	R L	302.0	.76	192.96	171.72	11.85	48.81	41.5

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER 
ERIC HESS



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18248

Purchase Order Date 10/25/12

PO Print Date 10/25/12

Page Number 1 of 1

Order From :

VC-MET001

METAUX CASTLE
A.M. CASTLE & CO. (CANADA) INC. - C/O 910720
P.O. BOX 4090 STN A
TORONTO, ON M5W OE9
CA

Contact Name

Vendor Phone 514 694 9575

Vendor Fax 514 695 3281

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
10/25/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6104-003P	17-4 SS Roundbar 3.25"OD	11/08/12	10.00	Yours ppd	\$44.0000	\$440.00
			Yes	Each			

Special Inst: AS PER DWG: D6104 REV: B
B92197
S.S. ROUND BILLET 03.25" X 3.80" LONG
TOLERANCE ARE +0.030"/-0.000"
MAT: 17-4PH STAINLESS STEEL
AMS 5643 OR AISI 630
ONE BLANK MAKES 2 PARTS

PO Total:

\$440.00

CERTIFICATE OF CONFORMITY
REQ. UPON DELIVERY

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required YES NO

Change Nbr: 1

Change Date: 10/25/12

Castle Metals FP

HEAT NUMBER

9EY4

MECHANICAL ID

ITEM CODE

4247D

LOT NUMBER

PO NUMBER

RECEIPT DATE

SUPPLIER

SPECIFICATION

LCS

COMMENT

APPROVED

NO

104195

5-31-2011

NH5

61